

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017173**Date Inspected:** 19-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Steel Barrier weld, W5-SB1-005-013. ZPMC welder was identified as 037944. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of OBG Steel Barrier weld, W5-SB1D-001-046. ZPMC welder was identified as 068994. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of OBG Steel Barrier weld, W5-SB1-007-015. ZPMC welder was identified as 068047. ZPMC CWI was identified as Wang Jie. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Caltrans QA observed excavations of Ultrasonic repairs exceeding 65% of base material material thickness of the following Longitudinal Diaphragm welds:

LD3033-001-038, 36mm excavated of 40mm stiffener weld (13CW).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

LD3033-001-042, 34mm excavated of 40mm stiffener weld (13CW).

LD3031-001-065, 28mm excavated of 40mm stiffener weld (13AW).

LD3031-001-029, 33mm excavated of 40mm stiffener weld (13AW).

LD3034-001-070, 12mm excavated of 18mm base material (13AW).

ZPMC stated they will submit a Critical Weld Repair (CWR) for the above mentioned excavation areas that exceeded 65% of SPCM welds and base material.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
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Reviewed By:	McClendon,Timothy	QA Reviewer
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